

Work Order ID 72144

Tuesday, July 19, 2011 1:45:00 PM

Page 1

Item ID: D3537-3

Accept

Revision ID:

Item Name: Wearpad

Start Date: 7/19/2011 Start Qty: 10.00

Required Date: 7/25/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-

Debur if necessary

364 . 663

B11-8-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Suloslos

414

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 72144

Tuesday, July 19, 2011 1:45:00 PM



Page 3

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 7/19/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/11

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/11

(signature)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8-15

0.00

8-45

320 OF

M 117338

14X Ø m-11/04/01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID 72144

Tuesday, July 19, 2011 1:45:00 PM

Page 4

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Item Name: Wearpad

Start Date: 7/19/2011 Start Qty: 10.00

Required Date: 7/25/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

14

d

11/09/11

200

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF

11-09-11

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 1:45:06 PM

Page 1

Work Order ID: 72144

Parent Item: D3537-3

Parent Item Name: Wearpad




Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA  | | Purchased | No | | | 100 | sf | 222.7000 | 0.149 | 1.568421 | | | |
| 304/316 Sheet .063 | | | | | | | | | | | | | |



B11-8-4

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT020 | 22.7 | |
| 117275 | 1.7 | |
| 117653 | 21 | |
| MAT021 | 200 | |
| 118217 | 200 | |

118217

(14)

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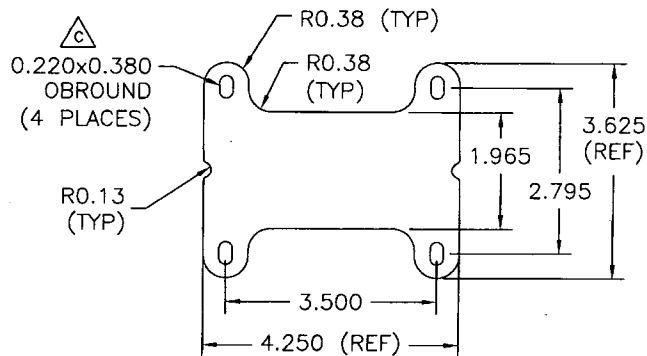
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NOTE: Date & initial all entries

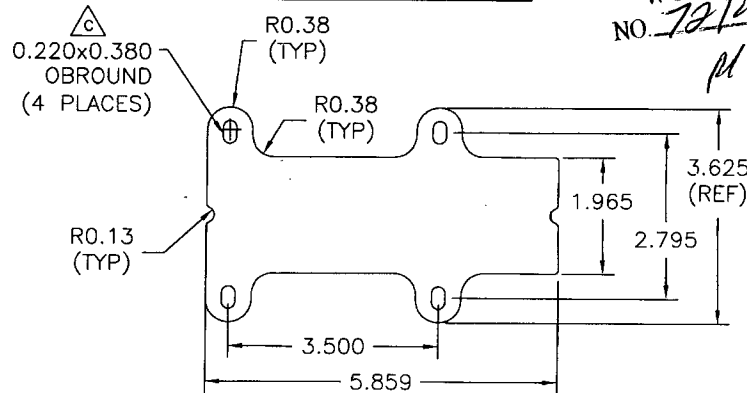
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 72144
M110710

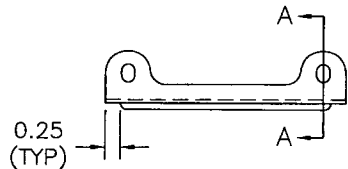
D3537-1F FLAT PATTERN



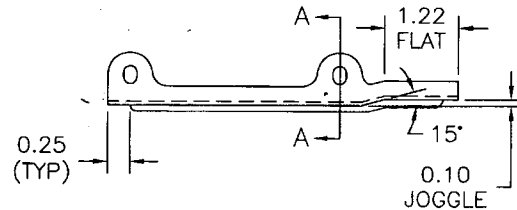
D3537-3F FLAT PATTERN



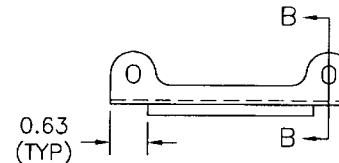
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



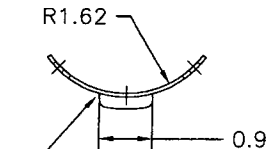
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

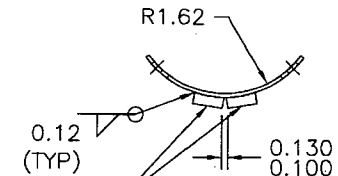


SECTION A-A



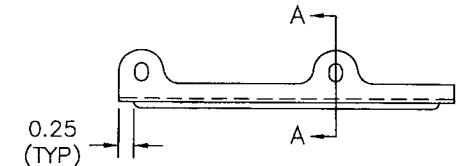
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

| | | |
|-------------|----------|----------------------------------|
| C | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B | 07.03.20 | ADD AMS 5513 AND AMS 5524 |
| A | 06.11.06 | NEW ISSUE |
| DESIGN | C.B. | DRAWN BY P.H. |
| CHECKED | A | APPROVED A |
| DATE | 07.04.13 | TITLE WEARPAD |
| DRAWING NO. | D3537 | REV. C |
| | | SHEET 1 OF 1 |
| | | SCALE 1:2 |

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08 AM
per ECU 962

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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